



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-827-011
Job Sheet 190021



008400

Part No: D119-827-011

Job Qty: 1 pcs

Part Name: Tail Rotor Pedal Lockout



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/4/19

Job Tracking No:

Due Date: 2/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 13270

Note: DWG REV E IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP REV:B 13-01-09 REV B JLM
VERIFIED:DD IPP REV:C 12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
						Workcenter / Supplier Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	2/27/19		0.00 0.00	Packaging 1 - 1	
						Packaging 1 - 2	
						Packaging 1 - 3	
						Packaging 1 - 4	
						Packaging 1 - 5	
						Packaging 1 - 6	
						Packaging 1 - 7	
						Packaging 1 - 8	
						Packaging 1 - 9	
						Packaging 1 - 10	
						Packaging 1 - 11	
						Packaging 1 - 12	
						Packaging 1 - 13	
						Packaging 1 - 14	
						Packaging 1 - 15	
						Packaging 1 - 16	
						Packaging 1 - 17	
						Packaging 1 - 18	
						Packaging 1 - 19	
						Packaging 1 - 20	
						Packaging 1 - 21	
						Packaging 1 - 22	
						Packaging 1 - 23	
						Packaging 1 - 24	
						Packaging 1 - 25	
						Packaging 1 - 26	
						Packaging 1 - 27	
						Packaging 1 - 28	
						Packaging 1 - 29	
						Packaging 1 - 30	

DART
AEROSPACE

Container No: S158096



Part: D119 - 827 - 011
Job No: 190021
Serial No/Batch: S158096

Revision:
Inspector:
Exp Date:
Instructions: FAA STC SR02258SE 18/04/17, 17/07/18, 16/08/18, 16/09/18, 16/10/18, 16/11/18, 16/12/18, 17/01/19, 17/02/19, 17/03/19, 17/04/19, 17/05/19, 17/06/19, 17/07/19, 17/08/19, 17/09/19, 17/10/19, 17/11/19, 17/12/19, 18/01/20, 18/02/20, 18/03/20, 18/04/20, 18/05/20, 18/06/20, 18/07/20, 18/08/20, 18/09/20, 18/10/20, 18/11/20, 18/12/20, 19/01/21, 19/02/21, 19/03/21, 19/04/21, 19/05/21, 19/06/21, 19/07/21, 19/08/21, 19/09/21, 19/10/21, 19/11/21, 19/12/21, 20/01/22, 20/02/22, 20/03/22, 20/04/22, 20/05/22, 20/06/22, 20/07/22, 20/08/22, 20/09/22, 20/10/22, 20/11/22, 20/12/22, 21/01/23, 21/02/23, 21/03/23, 21/04/23, 21/05/23, 21/06/23, 21/07/23, 21/08/23, 21/09/23, 21/10/23, 21/11/23, 21/12/23, 22/01/24, 22/02/24, 22/03/24, 22/04/24, 22/05/24, 22/06/24, 22/07/24, 22/08/24, 22/09/24, 22/10/24, 22/11/24, 22/12/24, 23/01/25, 23/02/25, 23/03/25, 23/04/25, 23/05/25, 23/06/25, 23/07/25, 23/08/25, 23/09/25, 23/10/25, 23/11/25, 23/12/25, 24/01/26, 24/02/26, 24/03/26, 24/04/26, 24/05/26, 24/06/26, 24/07/26, 24/08/26, 24/09/26, 24/10/26, 24/11/26, 24/12/26, 25/01/27, 25/02/27, 25/03/27, 25/04/27, 25/05/27, 25/06/27, 25/07/27, 25/08/27, 25/09/27, 25/10/27, 25/11/27, 25/12/27, 26/01/28, 26/02/28, 26/03/28, 26/04/28, 26/05/28, 26/06/28, 26/07/28, 26/08/28, 26/09/28, 26/10/28, 26/11/28, 26/12/28, 27/01/29, 27/02/29, 27/03/29, 27/04/29, 27/05/29, 27/06/29, 27/07/29, 27/08/29, 27/09/29, 27/10/29, 27/11/29, 27/12/29, 28/01/30, 28/02/30, 28/03/30, 28/04/30, 28/05/30, 28/06/30, 28/07/30, 28/08/30, 28/09/30, 28/10/30, 28/11/30, 28/12/30, 29/01/31, 29/02/31, 29/03/31, 29/04/31, 29/05/31, 29/06/31, 29/07/31, 29/08/31, 29/09/31, 29/10/31, 29/11/31, 29/12/31, 30/01/32, 30/02/32, 30/03/32, 30/04/32, 30/05/32, 30/06/32, 30/07/32, 30/08/32, 30/09/32, 30/10/32, 30/11/32, 30/12/32, 31/01/33, 31/02/33, 31/03/33, 31/04/33, 31/05/33, 31/06/33, 31/07/33, 31/08/33, 31/09/33, 31/10/33, 31/11/33, 31/12/33, 32/01/34, 32/02/34, 32/03/34, 32/04/34, 32/05/34, 32/06/34, 32/07/34, 32/08/34, 32/09/34, 32/10/34, 32/11/34, 32/12/34, 33/01/35, 33/02/35, 33/03/35, 33/04/35, 33/05/35, 33/06/35, 33/07/35, 33/08/35, 33/09/35, 33/10/35, 33/11/35, 33/12/35, 34/01/36, 34/02/36, 34/03/36, 34/04/36, 34/05/36, 34/06/36, 34/07/36, 34/08/36, 34/09/36, 34/10/36, 34/11/36, 34/12/36, 35/01/37, 35/02/37, 35/03/37, 35/04/37, 35/05/37, 35/06/37, 35/07/37, 35/08/37, 35/09/37, 35/10/37, 35/11/37, 35/12/37, 3

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
120 QC 4	1 pcs	2/27/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	DAS
					QC 4 - 46	46 MAR 01 2019
130 Packaging 3-1 - Stock - B4B	1 pcs	2/27/19	0.00 0.00		Packaging 3 - 1 - B4B	9-89
					Packaging 3 - 2 - B4B	46 MAR 01 2019
					Packaging 3 - 3 - B4B	46 MAR 01 2019
					Packaging 3 - 4 - B4B	9-89
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
135 DC - 1 - B4B	1 pcs	2/27/19	0.00 0.00		DC - 1 - B4B	DAS
					DC - 2 - B4B	21 MAR 01 2019
140 QC 21 - FG	1 pcs	2/27/19	0.00 0.00		QC 21 - FG - 21	9-89
					QC 21 - FG - 70	DAS
					QC 21 - SA - 53	21 MAR 01 2019
Part Op 110 - (Pick Kit)						9-89
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)						
130 - Identify and pack for shipping as per PPP D119-827-011						
135 - (Document Control) Photocopy bluefile & type labels per PPP D119-827-011 CHG002						
140 - (QC21- Final Inspection - Work Order Release)						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5130325
D4703-041	Lock Pin Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5157981
D4704-041	Expandable Pin Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5154574
D4710-1	Spacer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5113878
D4721-1	Decal	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5106338
MS14144L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5000574 X 15135099 X 1
MS24665-153	Cotter Pin	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	F107139
NAS1149D0416J	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	FM131511
NAS1149D0463J	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5150216
NAS6604D16	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5093764

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN4-11A	2	108	0
	D4703-041	2	2	0
	D4704-041	1	0	0
	D4710-1	1	46	0
	D4721-1	1	11	0
	MS14144L4	2	14	0
	MS24665-153	2	502	0
	NAS1149D0416J	2	2,178	0
	NAS1149D0463J	8	5,031	0
	NAS6604D16	2	97	0

Part Specifications

Specifications could not be found.

Plex 2/4/19 10:54 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

4.0 PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		D119-827-011	TAIL ROTOR PEDAL LOCKOUT
	X	D109-827-013	TAIL ROTOR PEDAL LOCKOUT
2		D4703-041	LOCKOUT PIN ASSY
	1	D4703-045	LOCKOUT PIN ASSY
1		D4704-041	EXPANDABLE PIN ASSY
	1	D4704-043	EXPANDABLE PIN ASSY
1	1	D4710-1	SPACER
1	1	D4721-1	DECAL
	2	D5481-041	PLUG ASSEMBLY
2		AN4-11A	BOLT
	2	AN4H11A	BOLT
2		MS14144L4	NUT
2		MS24665-153	COTTER PIN
2		NAS1149D0416J	WASHER
8	2	NAS1149D0463J	WASHER
2		NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 (A109/A119) <i>Tail Rotor Pedal Lockout</i>	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 (206/407) <i>Tail Rotor Pedal Lockout</i>	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg
D109-827-013 (AW109SP) <i>Tail Rotor Pedal Lockout</i>	0.54 lb 0.24 kg	32.6 in 0.83 m	17.6 in-lb 0.20 m-kg	-13.1 in -0.33 m	-7.1 in-lb -0.08 m-kg